












Date: Tuesday, 15/07/2008 9:19:17 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE
Job Number	: 40502		
Estimate Number	: 10366		
P.O. Number	:	Part Number	: D412742013
This Issue	: 15/07/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: N/A
First Issue	: //	Project Number	: N/A
Previous Run	: 40501	Drawing Revision	: D
Written By	:	Material	:
Checked & Approved By	: <u>JLD 08.15.08</u>	Due Date	: 15/08/2008
Comment	Est Rev: A 05.10.13 New Issue KJ/JLM Est Rev: B 06-06-08 As per DSI9336 JLM Est Rev: C 07-12-03 ECN 1072 DD verified by: JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		 <i>Scanned</i>	
Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D412-742-013 CHG004 <i>005 9C01 08/510</i>			
2.0	40502A	FLOAT SKID ASSEMBLY	
			
Comment: Sub-Component FLOAT SKID ASSEMBLY 1 x D412-742-043 Batch <u>B 40502A</u> <i>JS 08/08/28</i> <i>AD</i>			
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Pick Packing Kit			
4.0	D2571	Saddle, Fwd Out 205	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2571 Saddle Fwd Outside <u>40514</u> <i>JS 08/08/28</i> <i>AD</i>			
5.0	D2572	Saddle, Fwd In 205	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2572 Saddle Fwd Inside <u>40515</u> <i>JS 08/08/28</i> <i>AD</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:19:17 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 40502

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D2573	Saddle, Aft Out 205
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2573 Saddle Aft Outside

40198

JS 08/08/28 (X)

7.0	D2574	Saddle, Aft In 205
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2574 Saddle Aft Outside

40199

JS 08/08/28 (X)

8.0	D2876	Saddle Spacer
-----	-------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D2876 Saddle Spacer

36275

JS 08/08/28 (X)

9.0	D2877	Saddle Spacer
-----	-------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D2877 Saddle Spacer

36276

JS 08/08/28 (X)

10.0	D34031	Bushing
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description

Batch

16 D3403-1 Bushing

37547

JS 08/08/28 (X)

11.0	D2747	Set Screw
------	-------	-----------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description

Batch

4 D2747 Bolt

39224

JS 08/08/28 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:19:17 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 40502

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	D35331	Set Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Set Screw B: 28093

JS 08/08/28 @

13.0	AN4C6A	Bolt
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Pick:
Qty Part Number Description Batch
16 AN4C6A Bolt M67242

JS 08/08/28 @

14.0	AN4C52A	BOLT
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:
Qty Part Number Description Batch
8 AN4C52A Bolt M105423

JS 08/08/28 @

15.0	AN6C12A	BOLT
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:
Qty Part Number Description Batch
8 AN6C12A Bolt M104289

JS 08/08/28 @

16.0	D36723	Phenolic Washer
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Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)
PHENOLIC WASHER 37374

JS 08/08/28 @

17.0	AN960C416L	WASHER
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Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)
WASHER M167008 x27 M108558 x5

JS 08/08/28 @

18.0	D36729	Phenolic Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
PHENOLIC WASHER D35523

JS 08/08/28 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:19:17 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 40502

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	AN960C616L	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
WASHER

M107242

JS

08/08/28 (X)

20.0	D367211	Phenolic Washer
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
PHENOLIC WASHER

35524

JS

08/08/28 (X)

21.0	MS210434	Nut
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)
Nut

M108672

JS

08/08/28 (X)

22.0	AN4C7A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: M106302

JS

08/08/28 (X)

23.0	D34033	Bushing
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:
Qty Part Number Description Batch
8 D3403-3 Bushing

39130

JS

08/08/28 (X)

24.0	D3405041	Lug Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3405-041 GHW Lug

35779

JS

08/08/28 (X)

25.0	D3405043	Lug Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3405-043 GHW Lug

34841

JS

08/08/28 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:19:17 AM
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Drawing Name: FLOAT SKIDTUBE

Job Number: 40502

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation: Description :

26.0 AN4C46A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 AN4C46A Bolt 07287

JS 08/08/28(X)

27.0 MS210434 Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Pick:

Qty Part Number Description Batch
29 MS21043-4Nut M168672

JS 08/08/28(X)

28.0 D3407041 Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3407-041 TOW RING 35780

JS 08/08/28(X)

29.0 D34173 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3417-3 WASHER 33519

JS 08/08/28(X)

30.0 D34561 Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3456-1 WASHER M46285

JS 08/08/28(X)

31.0 AN3C37A BOLT



Comment: Qty.: 1.0000 EACH(s)/Unit Total : 1.0000 EACH(s)

BOLT

108137

JS 08/08/28(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:19:17 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 40502

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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32.0	AN3C40A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT M106169

JS 08/08/28 (X1)

33.0	AN3C41A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT M108084

JS 08/08/28 (X1)

34.0	AN3C42A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT M106169

JS 08/08/28 (X1)

35.0	AN3C43A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT M106227

JS 08/08/28 (X1)

36.0	AN3C46A	BOLT
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Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
BOLT M106169

JS 08/08/28 (X1)

37.0	AN960C10L	washer
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Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)
washer M108255

JS 08/08/28 (X1)

38.0	MS210433	Nut
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Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Nut M108672

JS 08/08/28 (X1)

39.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

JS 08/08/28 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:19:17 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 40502

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

PACKAGING 1

PACKAGING RESOURCE #1



①A

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-013

Location: *W 12*

8/8/09

SP

41.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

Done 8/8/09

Job Completion



U 8.8.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

33

Date: Tuesday, 15/07/2008 9:19:17 AM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 40502

Estimate Number : 10366

P.O. Number :

This Issue : 15/07/2008 S.O. No. :

Prsht Rev. : NC

First Issue : // Type : SKIDTUBES

Previous Run : 40501

Written By :

Checked & Approved By : JLD 08.15.08

Comment :

Est Rev: A 05.10.13 New Issue KJ/JLM

Est Rev: B 06-06-08 As per DSI9336 JLM

Est Rev: C 07-12-03 ECN 1072 DD verified by: JLM

Drawing : FLOAT SKIDTUBE

Part Number : D412742013

Drawing Number : N/A

Project Number : N/A

Drawing Revision : D

Material :

Due Date : 15/08/2008 Qty: 1 Um: Each

REFERENCE ONLY

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JLD 08/8/7



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-742-013 CHG004

2.0 40502A FLOAT SKID ASSEMBLY



Comment: Sub-Component FLOAT SKID ASSEMBLY

1 x D412-742-043 Batch _____

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 D2571 Saddle, Fwd Out 205



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2571 Saddle Fwd Outside _____

5.0 D2572 Saddle, Fwd In 205



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2572 Saddle Fwd Inside _____

Date: Friday, 08/08/2008 10:18:09 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOAT SKID ASSEMBLY
Job Number :	40502A		
Estimate Number :	10756		
P.O. Number :		Part Number :	D412742043
This Issue :	08/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3391
First Issue :	15/07/2008	Project Number :	N/A
Previous Run :	40501A	Drawing Revision :	G
		Material :	
Written By :		Due Date :	15/08/2008
Checked & Approved By :		Qty:	1
Comment :	Est Rev A 05.10.13 New Issue KJ/JLM	Um:	Each
	Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC		
	Est Rev:C 07-05-28 As per Rev F JLM		
	Est Rev:D 07-12-04 ECN 1072 DD verified		
	by:JLM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

2.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

**CLEAN -DO NOT SPRAY LPS
 FORWARD TUBE TO SKIDTUBE CELL
 PER DSI 9364***

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 M107912

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291 M1108801

Expiry date: 08/10

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex exept ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon M1104251

A/R Sikaflex-241/-291 M1108801

Expiry date: 08/10

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

08-08-19 (X)

Date: Friday, 08/08/2008 10:18:10 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 40502A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: SKIDTUBESS RESOURCE 1

A) -DRILL 0.500 DIAM. HOLES THRU D3391-021 FWD TUBE AND D3391-023 MID TUBE(2 PLACES) AS SHOWN ON DSI 9364.

INSTALL D3591-1 BUSHING B 3/5/14

B) - DEBURR ALL HOLES

- TOUCH UP ALODINE

- TOUCH UP PAINT

C) - RECOAT WITH LPS3 B M104251

RETURN TUBE TO HAND FINISHING

-CONTINUE ON ASSEMBLY PER SEQ 2.0

DP
8-8-18

HP 0808-19 RU

3.1

D35911

Bushing

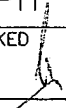


Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bushing

Job Completion



REFERENCE ONLY

DESIGN PH	DRAWN BY AJS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED	DRAWING NO. DSI 9364	REV. C SHEET 1 OF 1
DATE 08.08.06		TITLE BUSHING INSTALLATION	SCALE NTS
A	07.01.16	NEW ISSUE	
B	07.03.20	ADD TOLERANCE TO 1/2" HOLE	
C	08.08.06	ADDED CHG 005 & SUBS TO EFFECTIVITY	

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-742 REV. D AND ICA-D412-742 REV. 3

REF. FAA STC: SR01583SE

REF. CANADIAN STC: SH05-37 ISSUE 1

REF EASA STC: IM.R.S.01126

TO PREVENT THE D3391-011/-021 FWD TUBE FROM MOVING WITH RESPECT TO THE D3391-013/-023 MID TUBE, CUSTOMERS RECEIVING D412-742-011/-013 SKIDTUBES AT CHG 002 OR CHG 005 AND SUBSEQUENTS HAVE A D3591-1 BUSHING INSTALLED AT THE FWD SADDLE HOLES AS SHOWN IN DETAIL A (2 PLACES).

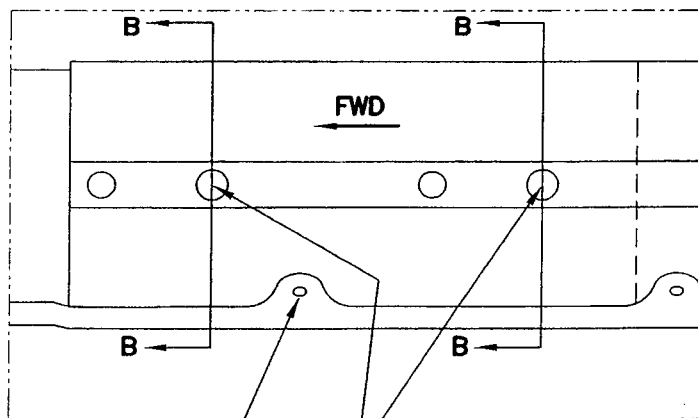
CUSTOMERS WITH D412-742-011/-013 SKIDTUBES AT CHG 001, CHG 003 AND CHG 004 CAN PROCURE THE DSI 9364-011 KIT AND INSTALL THE D3591-1 BUSHINGS AS FOLLOWS:

- 1) REMOVE SKIDTUBE/SADDLES FROM AIRCRAFT USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE.
- 2) TRANSFER DRILL 1/2" HOLES ($\varnothing 0.500 \pm 0.006_{-0.000}^{+0.006}$) INTO THE FWD SADDLE HOLES AT THE LOCATIONS SHOWN (2 PLACES) THRU THE D3391-013/-023 MID TUBE AND D3391-011/-021 FWD TUBE. DO NOT OPEN UP HOLES IN D2571/D2572 FWD SADDLES.
- 3) REMOVE FWD TUBE FROM MID TUBE, DEBURR DRILLED HOLES, TOUCH UP HOLES WITH MIL-P-85582 OR MIL-P-23377 PRIMER
- 4) RE-INSTALL D3391-011/-021 FWD TUBE INTO D3391-013/-023 MID TUBE USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE EXCEPT INSTALL D3591-1 BUSHINGS AS SHOWN IN DETAIL A USING LPS LABORATORIES LPS-3 CORROSION INHIBITOR PRIOR TO INSTALLING THE D2571/D2572 SADDLES.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9364-011	BUSHING INSTALLATION
2	D3591-1	BUSHING



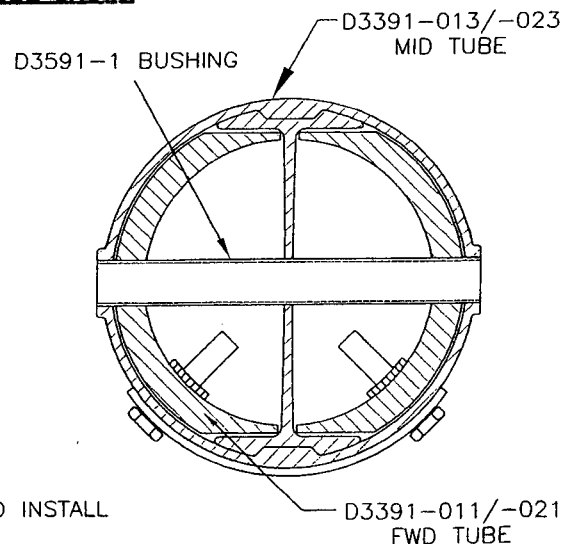
D412-742-011/-013 SKIDTUBE SHOWN



ENSURE BOLT IS FASTENED
PRIOR TO TRANSFER DRILLING
(REF)

OPEN TO $\varnothing 0.500 \pm 0.006_{-0.000}^{+0.006}$ AND INSTALL
D3591-1 BUSHING
(2 PLACES)

DETAIL A: D3591-1 BUSHING INSTALLATION LOCATION



SECTION B-B

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Date: Tuesday, 15/07/2008 9:19:32 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOAT SKID ASSEMBLY
Job Number :	40502A		
Estimate Number :	10756		
P.O. Number :		Part Number :	D412742043
This Issue :	15/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3391
First Issue :	/ /	Project Number :	N/A
Previous Run :	40501A	Drawing Revision :	G
	Type :	Material :	
	SKIDTUBES	Due Date :	15/08/2008
Written By :		Qty:	1
Checked & Approved By :	JUL 08.15.08	Um:	Each
Comment :	Est Rev A 05.10.13 New Issue KJ/JLM Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC Est Rev:C 07-05-28 As per Rev F JLM Est Rev:D 07-12-04 ECN 1072 DD verified by:JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------

**Comment:** DOCUMENT CONTROL

If D412-742-043 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-742-043 CHG003

2.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------

**Comment:** HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 _____

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291 _____

Expiry date: _____

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon _____

A/R Sikaflex-241/-291 _____

Expiry date: _____

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:19:32 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 40502A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

D3391023

Mid Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
pick:

Qty Part Number Description Batch

1 D3391-023 Mid Tube Assembly

B 40521 * YH

4.0

D3391025

Aft Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
pick:

Qty Part Number Description Batch

1 D3391-025 Aft Tube Assembly

B 39129 * OK

5.0

D35641

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B 33243

YH

6.0

D35661

Gasket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: B 40431

YH

7.0

D35643

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

B 34052

YH

Left

1 used

8.0

D35645

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

B 341145

YH

08-08-15

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:19:32 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 40502A

Part Number: D412742043

Job Number:



Seq. #: Machine Or Operation: Description :

9.0 D35665 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B341147 * SP

10.0 AN3C4A BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

BOLT

Batch: A1108599 * SP

11.0 AN3C6A BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

BOLT

Batch: M108744 * SP

12.0 AN3C7A BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

Batch: M107376 * SP

13.0 AN960C10L washer



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

washer

Batch: M108672 * SP

08-08-19

(X1)

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

080827 SP

15.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location: PPP 40502

PPP Rev: 8/8/25

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:19:32 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 40502A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2008.08.29

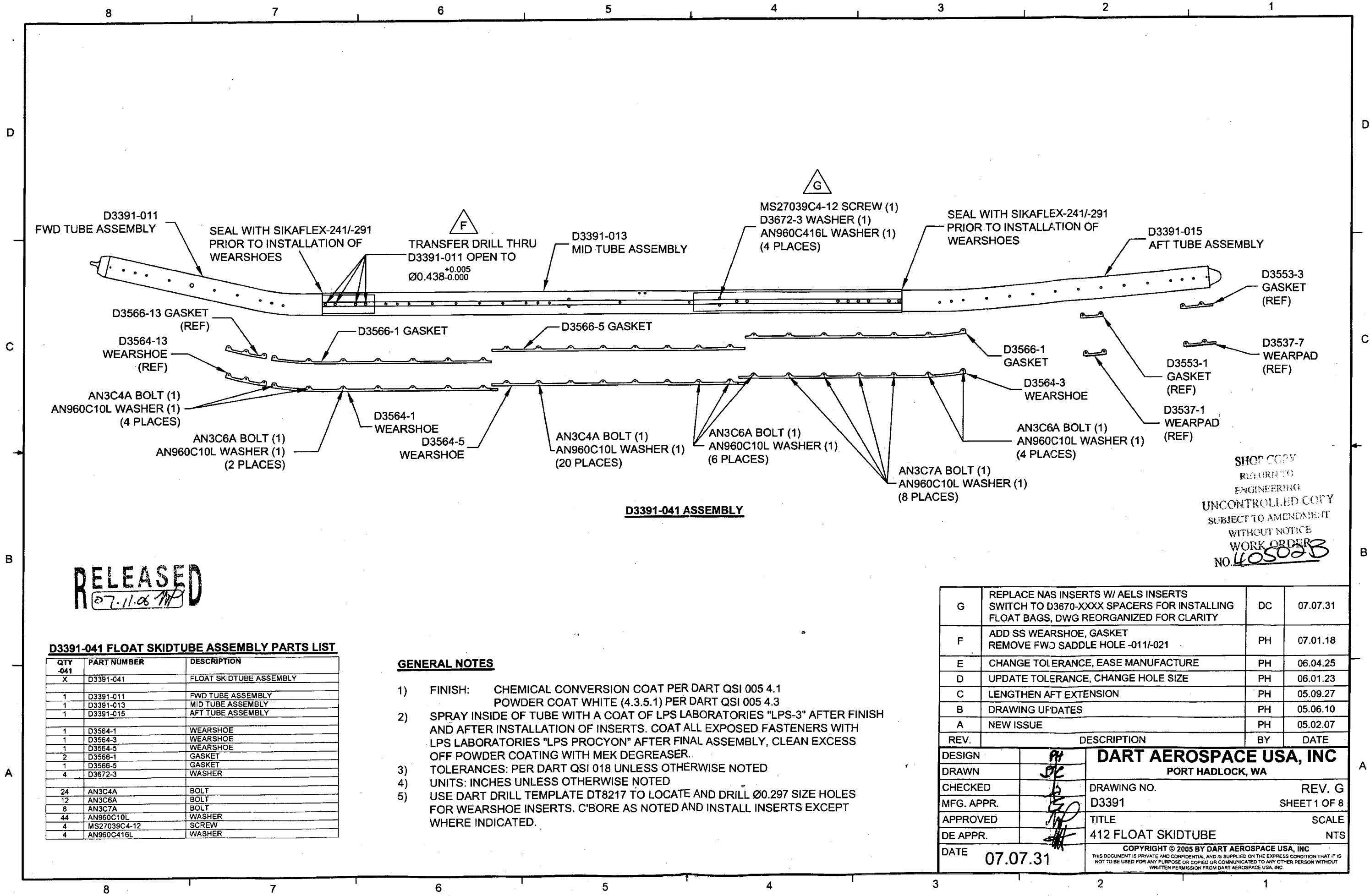
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
27-11-06 MP

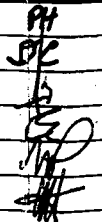
D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

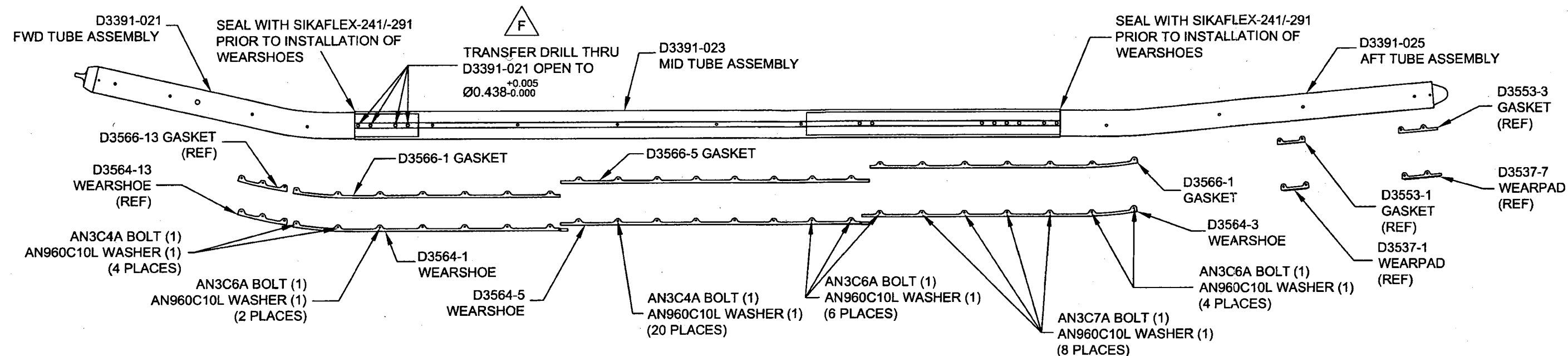
QTY	PART NUMBER	DESCRIPTION
-041		
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE

DESIGN		DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3391	SHEET 1 OF 8
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D3391-043 ASSEMBLY

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07.11.21

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

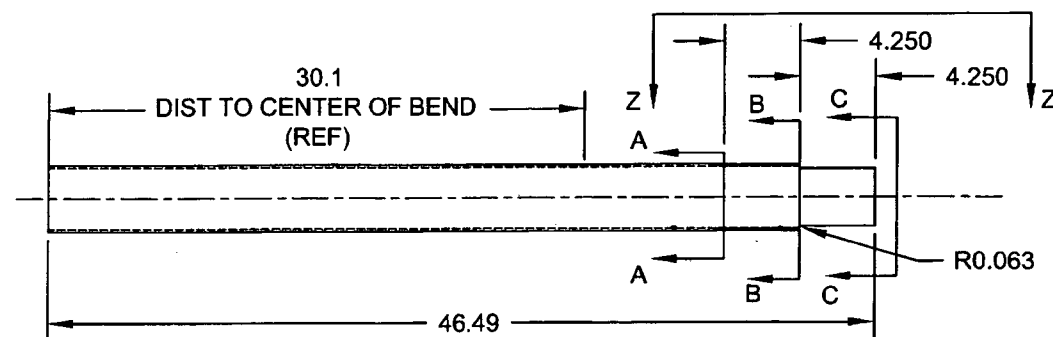
QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

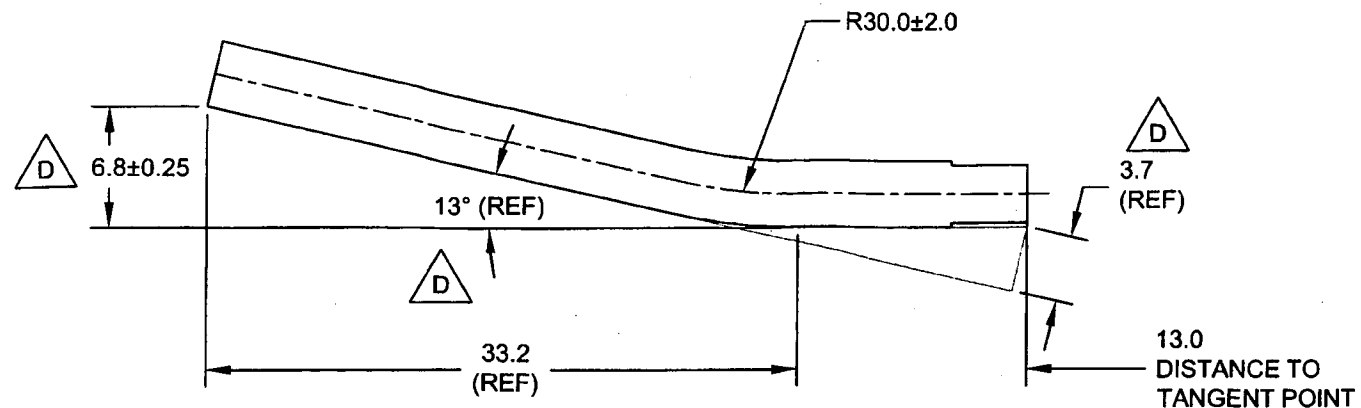
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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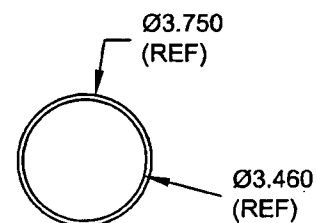
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	JLC	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. G
MFG. APPR.	ED	D3391	SHEET 2 OF 8
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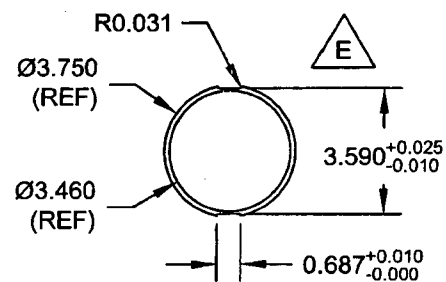
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



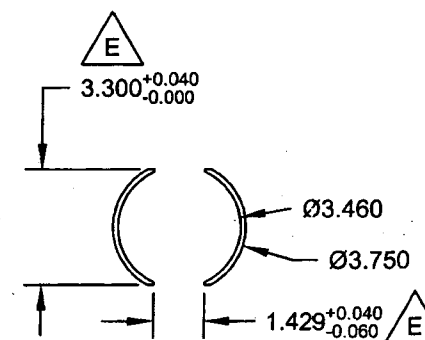
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



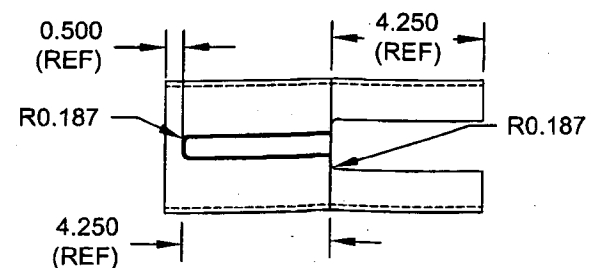
SECTION A-A
(SCALE 1:5)



SECTION B-B
(SCALE 1:5)



SECTION C-C
(SCALE 1:5)

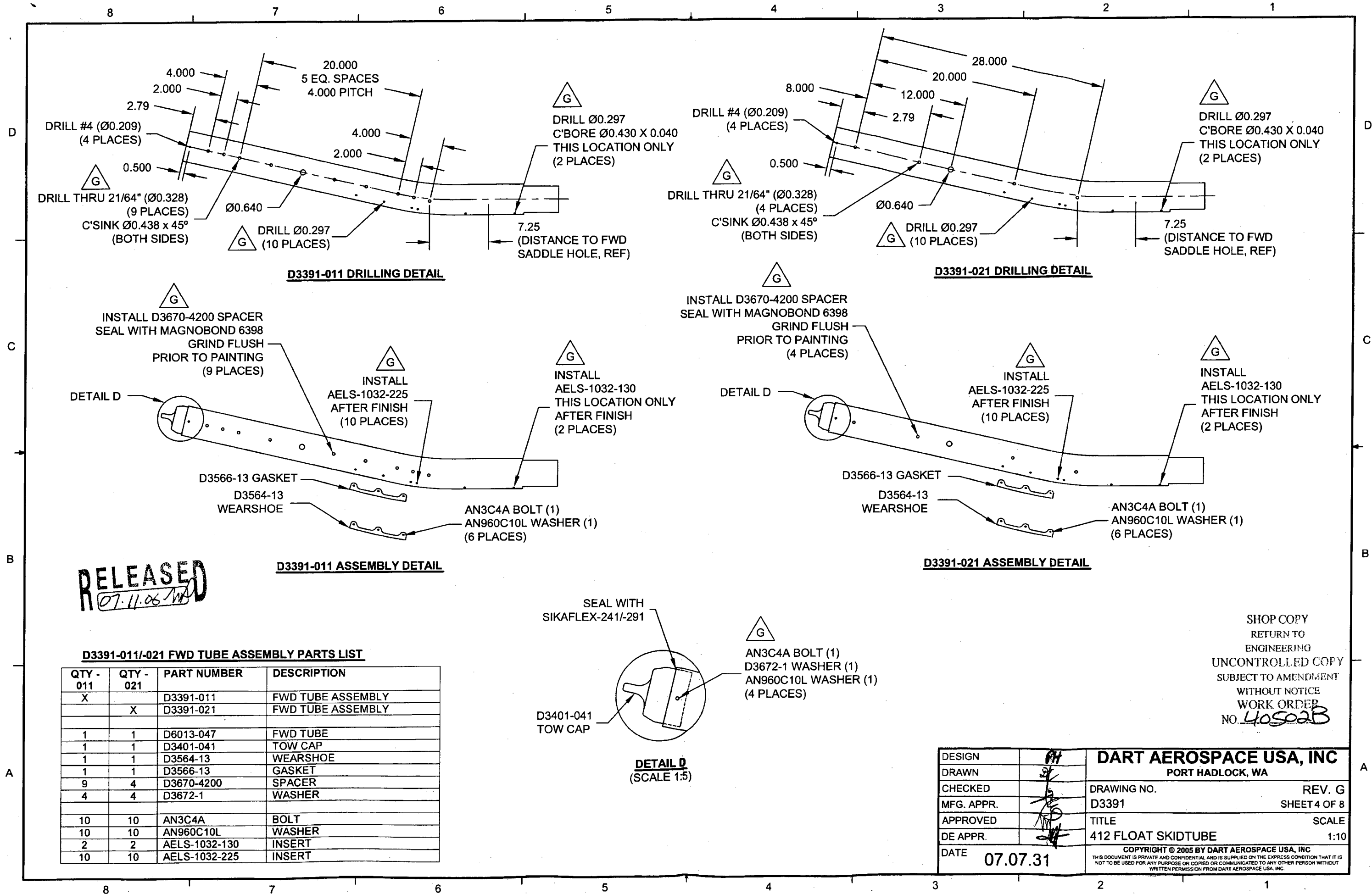


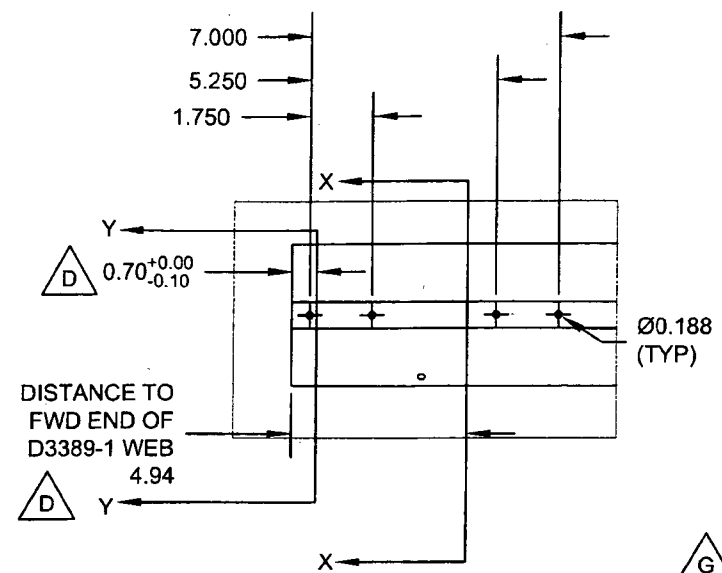
VIEW Z-Z
(SCALE 1:5)

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07-11-06

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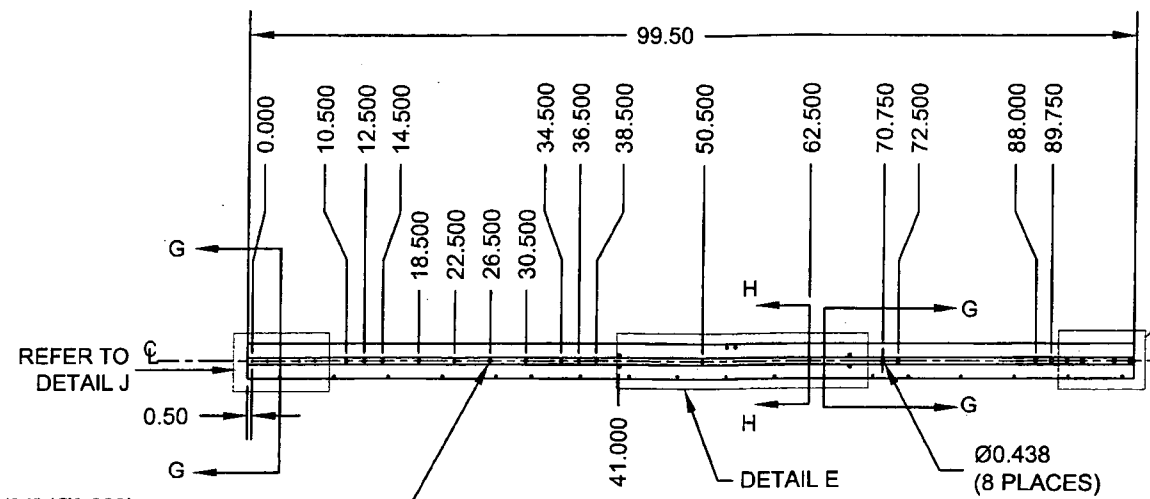
DESIGN		DART AEROSPACE USA, INC	
DRAWN	<i>JC</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D3391	SHEET 3 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	412 FLOAT SKIDTUBE	1:10
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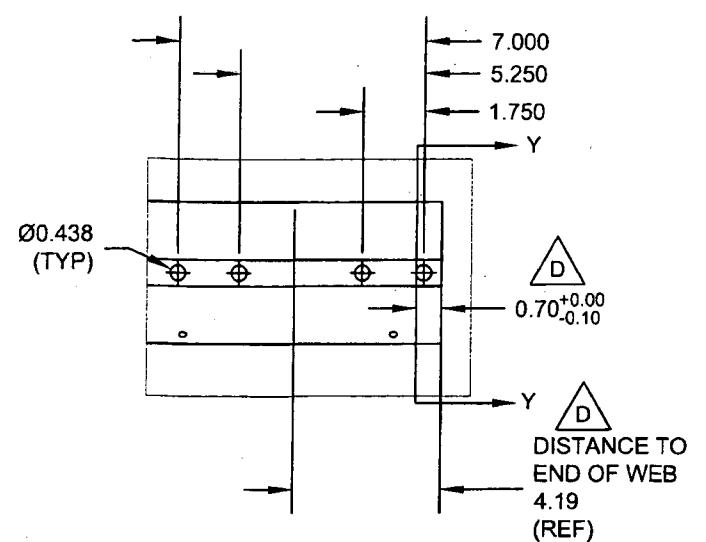


DETAIL J
(SCALE 1:5)

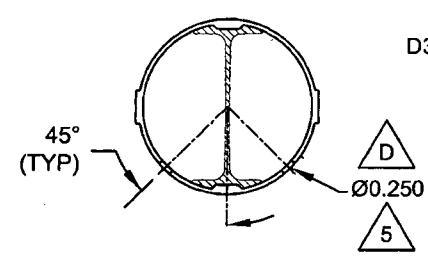
DRILL THRU 21/64" (Ø0.328)
C/SINK Ø0.438 X 45° (BOTH SIDES)
(12 PLACES)



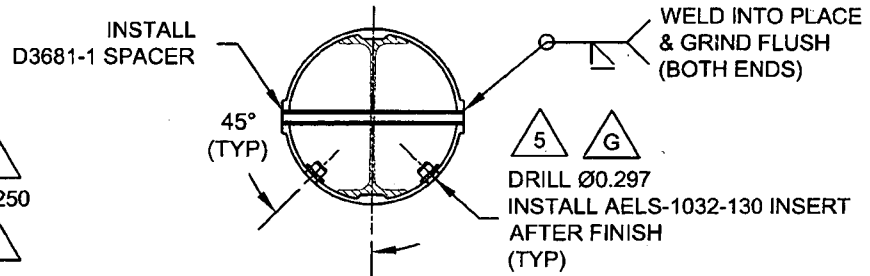
D3391-013 ASSEMBLY DETAIL



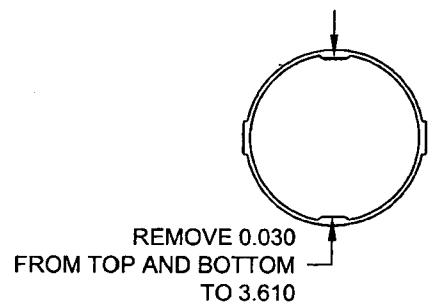
DETAIL K
(SCALE 1:5)



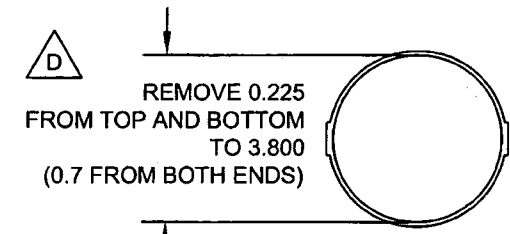
SECTION G-G
(SCALE 1:4)



SECTION H-H
(SCALE 1:4)

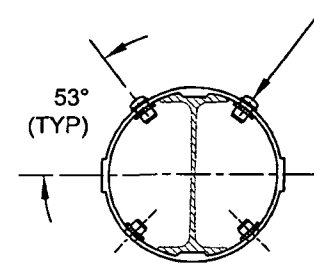


SECTION X-X
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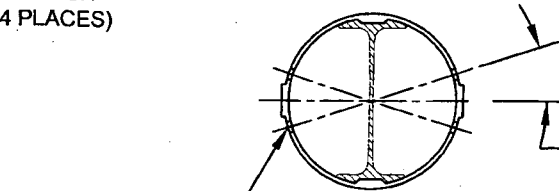


SECTION Y-Y
(SCALE 1:4)

DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
(TYP 4 PLACES)



SECTION M-M
(SCALE 1:4)

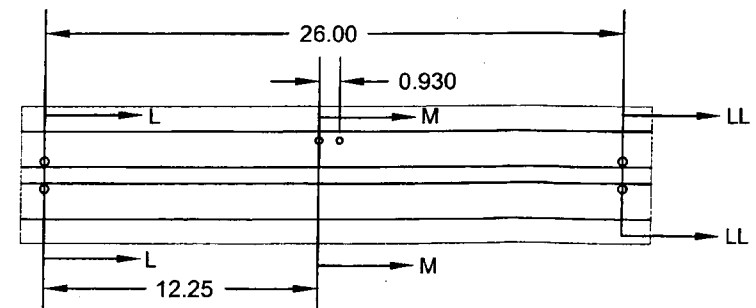


SECTION LL-LL
(SCALE 1:4)

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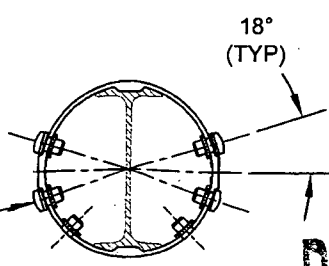
D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
12	D3681-1	SPACER
4	D3672-1	WASHER
4	D3672-3	WASHER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



DETAIL E
(SCALE 1:8)

DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
(TYP 4 PLACES)

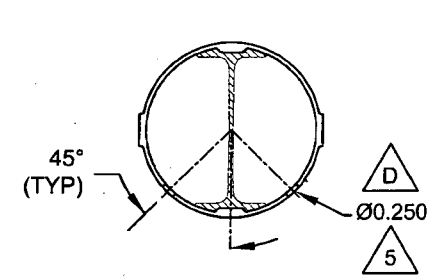
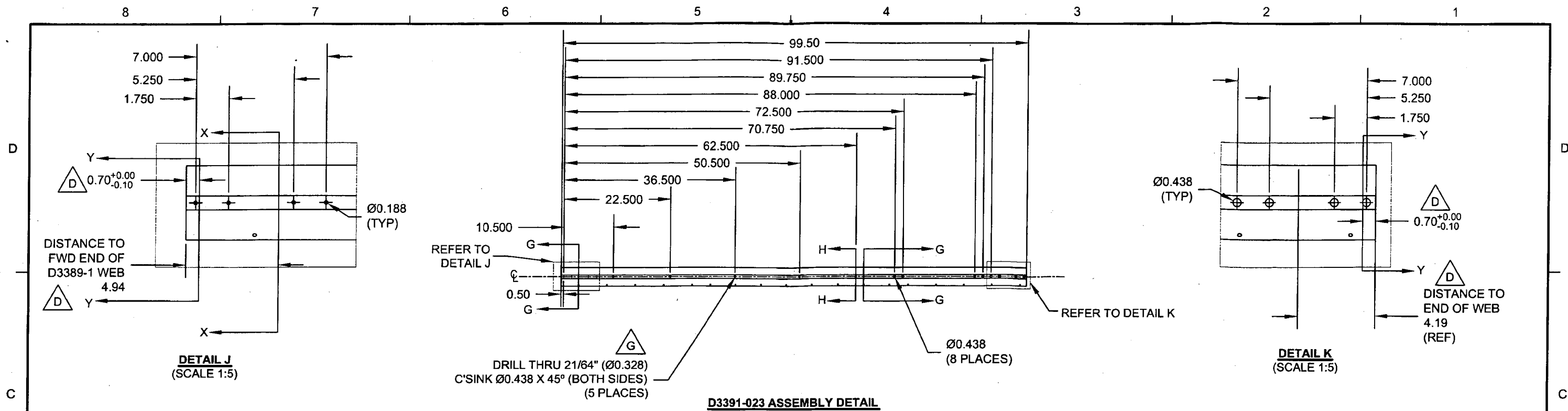


SECTION L-L
(SCALE 1:4)

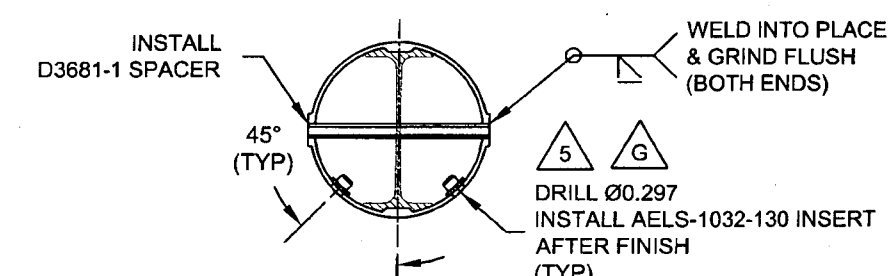
- D3391-013 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
 - 3) WELDING: PER DART QSI 004

RELEASED
27.11.06

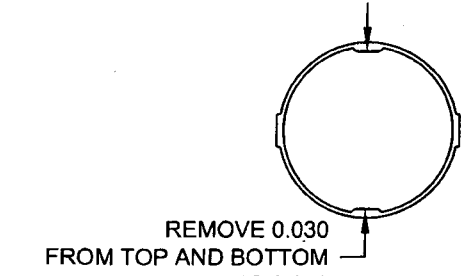
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	DP	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3391	SHEET 5 OF 8
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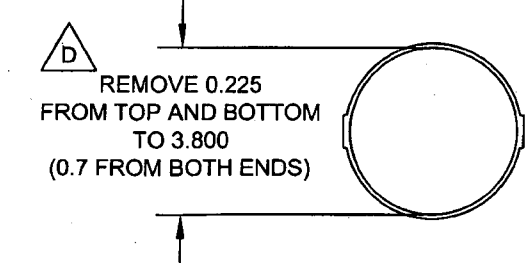
SECTION G-G
(SCALE 1:4)



SECTION H-H
(SCALE 1:4)



SECTION X-X
(SCALE 1:4)



SECTION Y-Y
(SCALE 1:4)

D3391-023 MID TUBE ASSEMBLY PARTS LIST

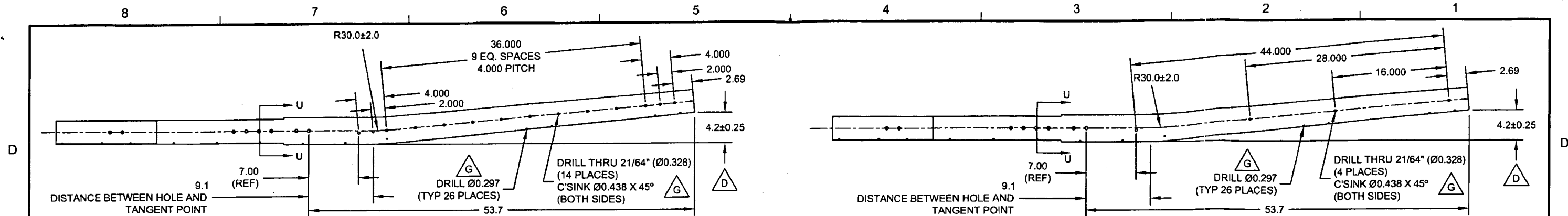
QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

- D3391-023 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
 - 3) WELDING: PER DART QSI 004

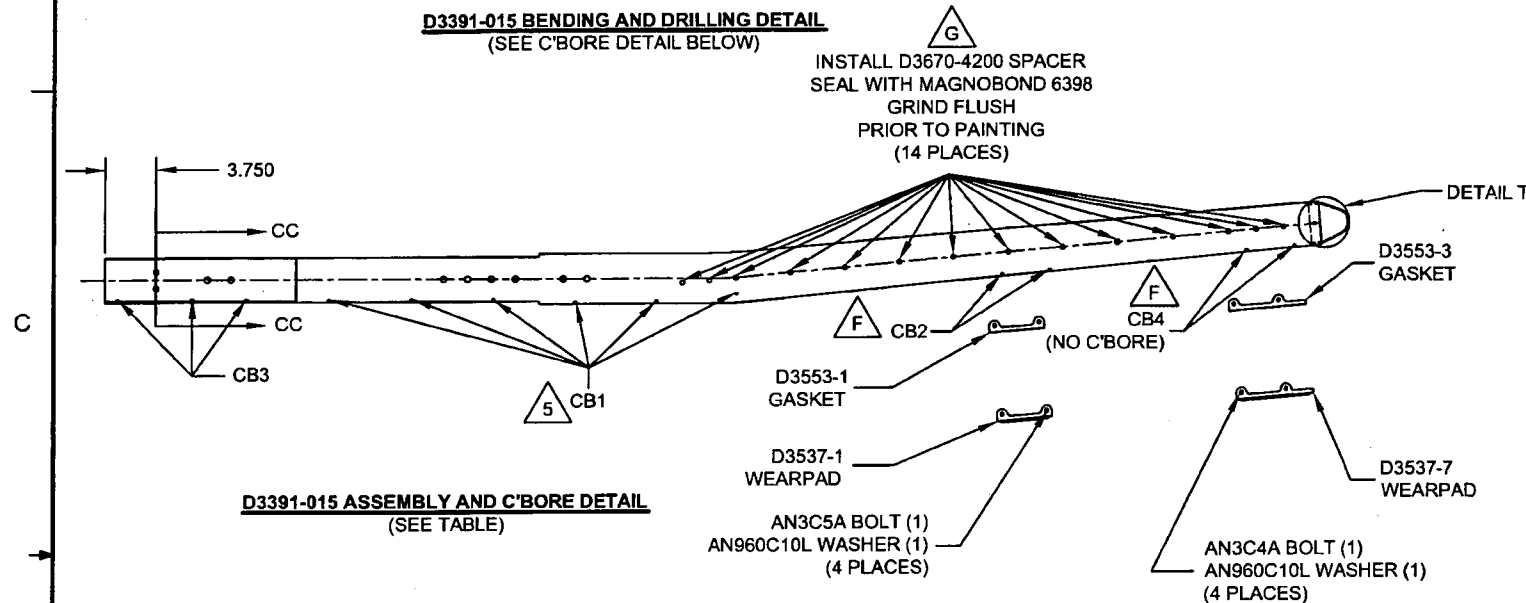
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07.11.06

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DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA
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CHECKED	JK	DRAWING NO. REV. G
MFG. APPR.	JK	D3391 SHEET 6 OF 8
APPROVED	JK	TITLE SCALE
DE APPR.	JK	412 FLOAT SKIDTUBE 1:20
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



D3391-015 BENDING AND DRILLING DETAIL
(SEE C'BORE DETAIL BELOW)



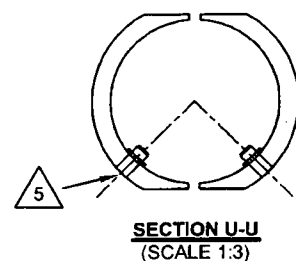
D3391-015 ASSEMBLY AND C'BORE DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

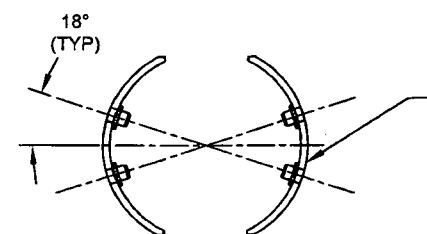
QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4		ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

C'BORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'BORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

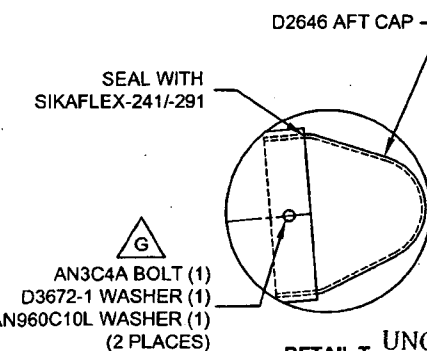


SECTION U-U
(SCALE 1:3)



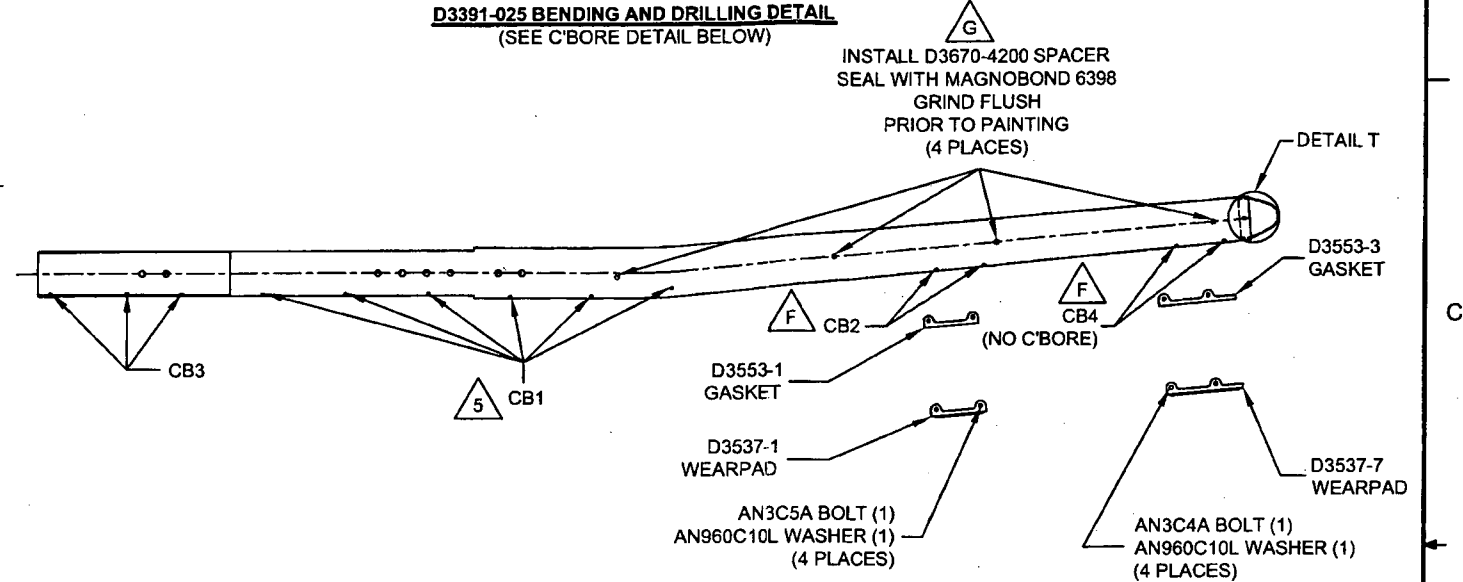
SECTION CC-CC
(SCALE 1:3)

DRILL Ø0.391
C'BORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT (1)
(4 PLACES)

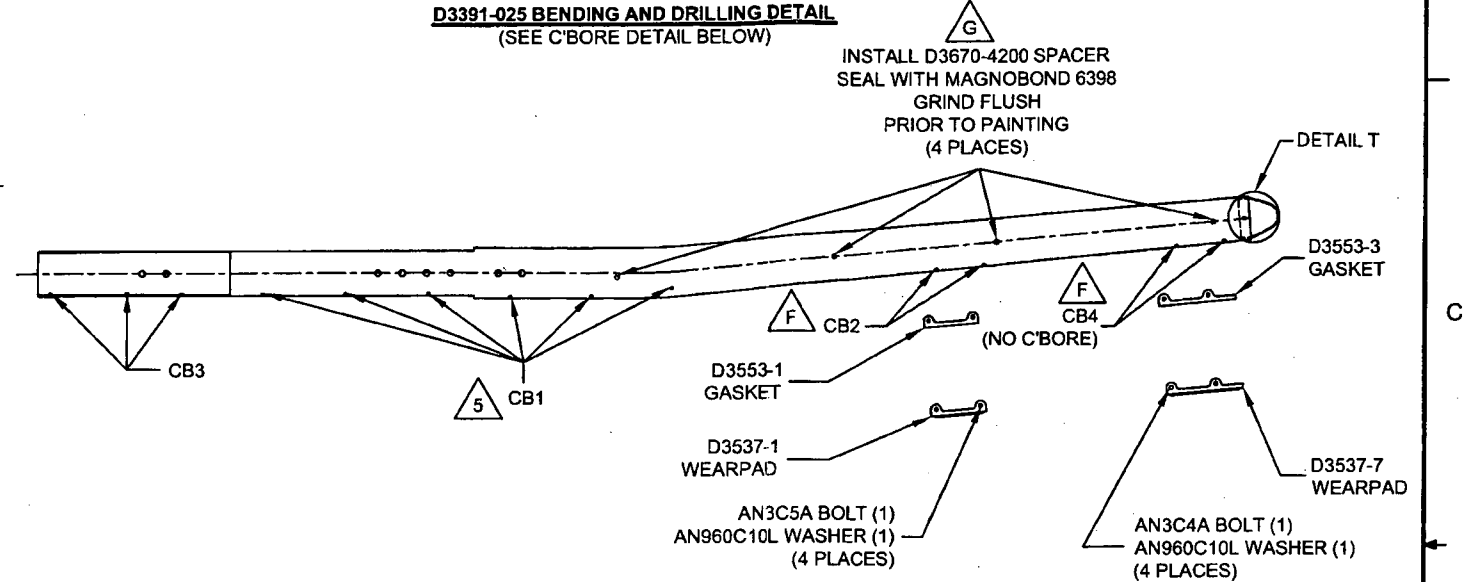


DETAIL T
(SCALE 1:3)

D3391-025 ASSEMBLY AND C'BORE DETAIL
(SEE TABLE)



D3391-025 BENDING AND DRILLING DETAIL
(SEE C'BORE DETAIL BELOW)



D3391-025 ASSEMBLY AND C'BORE DETAIL
(SEE TABLE)

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DE APPR.	5	412 FLOAT SKIDTUBE	1:12
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